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646.3510

Job Sheet 213986



Part No: 646.3510

Job Qty: 12 pcs

Part Name: Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/13/20

Job Tracking No:

Due Date: 10/29/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV N/C 3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	12 pcs		10/28/20	0.17	0.47	Waterjet - Flow		on 20/10/20
120	QC 2	12 pcs		10/28/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/10/27
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S308720



Part: 646.3510

Job No: 213986

Serial No/Batch: S308720

Revision: N/C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/28/20

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130	QC 8	12 pcs	10/28/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Large Fab - Welded Assy-1	12 pcs	10/28/20	0.00 4.80	Large Fab - 1 - B4B
					Large Fab - 10 - B4B
					Large Fab - 2 - B4B
					Large Fab - 3 - B4B
					Large Fab - 4 - B4B
					Large Fab - 5 - B4B
					Large Fab - 6 - B4B
					Large Fab - 7 - B4B
					Large Fab - 8 - B4B
					Large Fab - 9 - B4B
					Large Fab - 11 - B4B (Various)
					Large Fab - 12 - B4B
150	QC 5	12 pcs	10/28/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3

DAS
40
9-89

NOT 27 2020

MW Oct 28/20

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS
					QC 5 - 50	50 10-28-20
					QC 5 - 30	9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
160	Large Fab - Welded Assy-2-B4B	12 pcs	10/28/20	0.00 4.00	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	MV 10-28-20
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
170	QC 9	12 pcs	10/28/20	0.00 0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	DAS
					QC 9 - 50	50 10-30-20
					QC 9 - 9	9-89
180	QC 5	12 pcs	10/28/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS
					QC 5 - 50	50 10-30-20
					QC 5 - 30	9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
220	Spray Paint - 2 - B4B	12 pcs	10/29/20	0.00 0.44	Spray Paint - 1 - B4B	DAS
					Spray Paint - 2 - B4B	41 NOV 01 2020
					Spray Paint - 3 - B4B	9-89
					Spray Paint - 4 - B4B	
230	QC 14	12 pcs	10/29/20	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	

					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	DAS
					QC 14 - 81	81
					QC 14 - 82	9-89
					QC 14 - 87	
					QC 14 - 47	
240	Packaging 3-1 - Stock - B4B	12 pcs	10/29/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	NOV 02 2020
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
250	QC 21 - SA	12 pcs	10/29/20	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 9	9-89
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 110 - 1-Cut 646.3500 plate 2.75"x 1.50" as per Dwg Prog Rev: _____ 2-Deburr if necessary
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)

- 140 - 1- Fabricate tube as per dwg USE DT10290 PUNCH
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - Weld tube to plate as per dwg. DT9867 Weld end were tube is punch.
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 220 - Prime as per dwg (see note 3) Batch: 5265778
 230 - (QC14- Inspect Spray Paint)
 240 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
 250 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.3336 sf (.0278 ea)	110-Waterjet - Flow - 1	<u>5301305</u>
M304TR0.500W.049	304 Round Tube .500 X .049W	9.9960 ft (.833 ea)	140-Large Fab - Welded Assy-1	<u>5272352</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	0	160	0
140-Large Fab - Welded Assy-1	M304TR0.500W.049	10	67	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	2.750Inches ± 0.030	2.780 2.720	<u>2.755</u>	
2	Strut	1.500Inches ± 0.030	1.530 1.470	<u>1.504</u>	
3	Strut	0.063Inches ± 0.010	0.073 0.053	<u>1.058</u>	

Plex 10/13/20 12:42 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY			
Other/Details:					



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Date: 10/27/20